

Date: Thursday, 5/4/2006 11:09:41 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 26928B		
Estimate Number	: 10378		
P.O. Number	: N/A	Part Number	: D30653
This Issue	: 5/4/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3065 REV. A2
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26452B	Drawing Revision	: A2
		Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 5/15/2006
Checked & Approved By	: <u>06.05.05</u>	Qty:	67 Um: Each
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2287 sf(s)/Unit Total: 13.7214 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch: M19295

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D
 Dwg Rev: A2
 Prog Rev: A2

MA 06 05 18
SAD 06:05:18 (67)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr Stack

En 06/05/26 x (67)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:09:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 26928B

Part Number: D30653

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB

06/07/04

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/07/05

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 06/07/05

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6A

SB 06/07/05

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/06

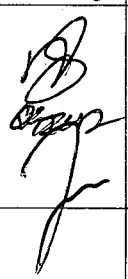
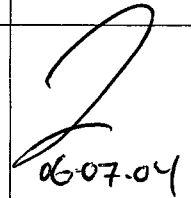
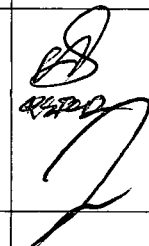
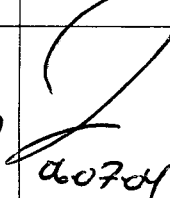
Job Completion



W 06/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 0607106
 QA: N/C Closed: _____ Date: _____

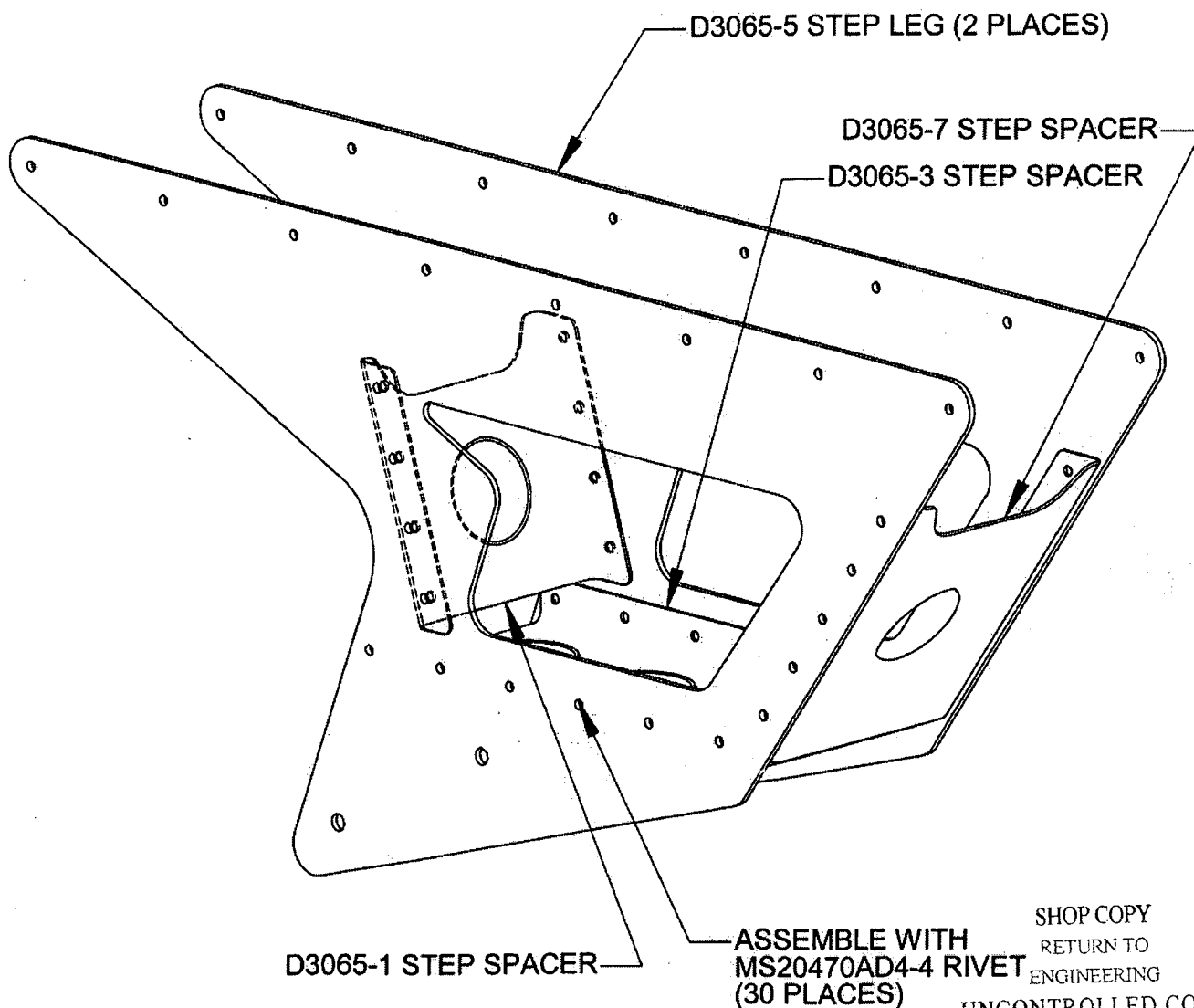
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
060704	6	2 parts bent out of tolerance. f. + will not con. form. 2 parts scrap, upon set-up, → too wide.		Scrap: destroy.	SB 06/07/04	 06-07-04		 060704

NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. A SHEET 1 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
A1	03.02.13 <i>qp</i>	ADD SLOTS TO D3065-5	
A2	03.02.27 <i>qp</i>	0.551 WAS 0.410	

RELEASED
02.09.20 *#*



D3065-041 STEP LEG ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO. **26928B**

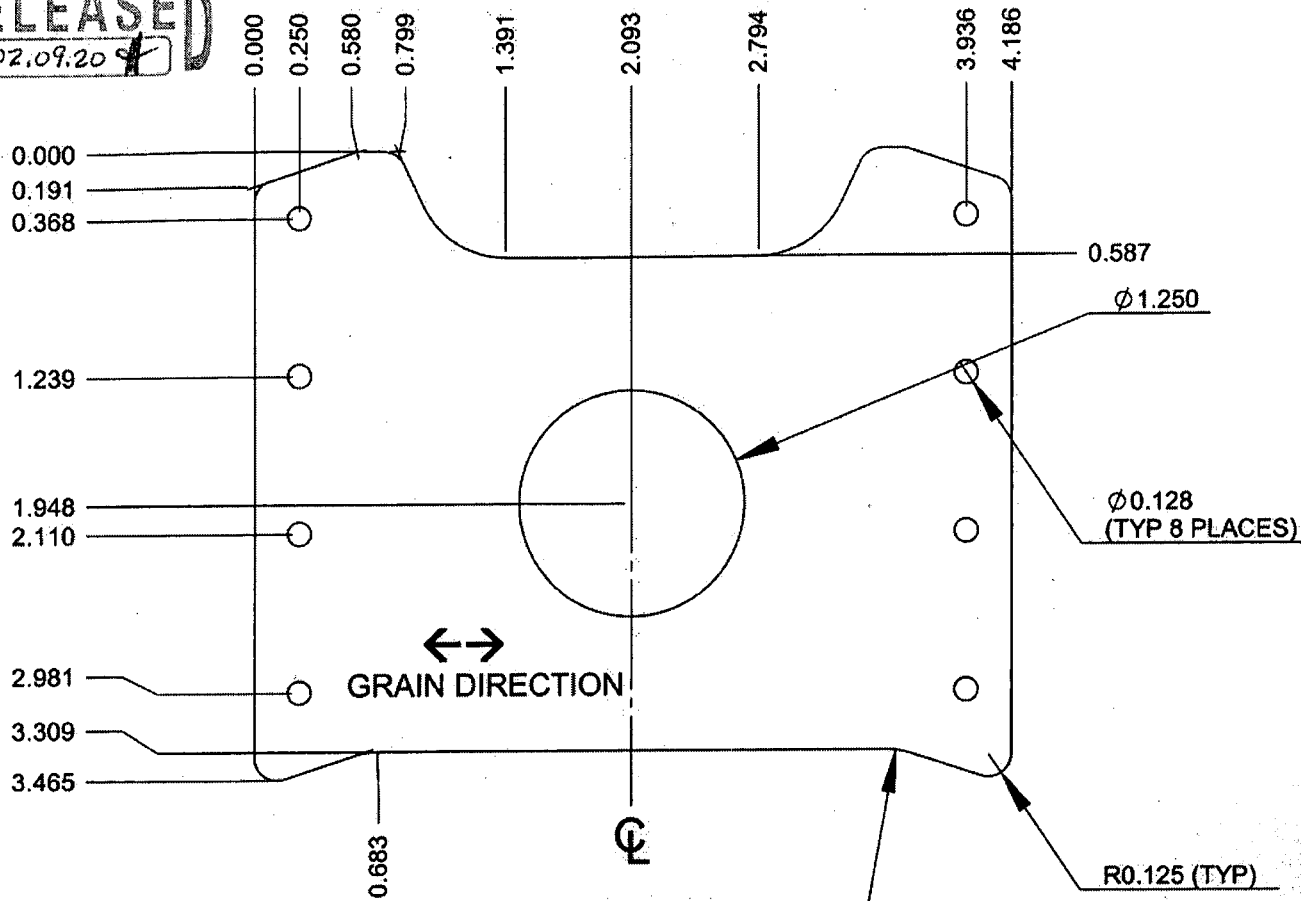
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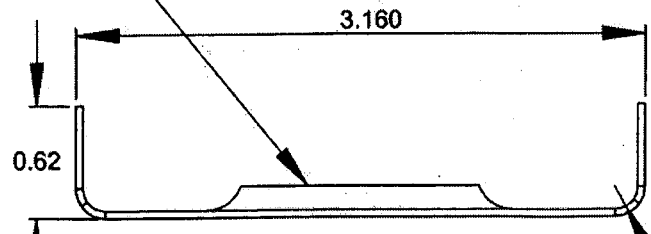
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 2 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20



FLANGE AFTER BENDING
TOWARDS SIDE SHOWN
USING DT8174
(2 PLACES)

FLAT PATTERN



BEND DETAIL

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 269283

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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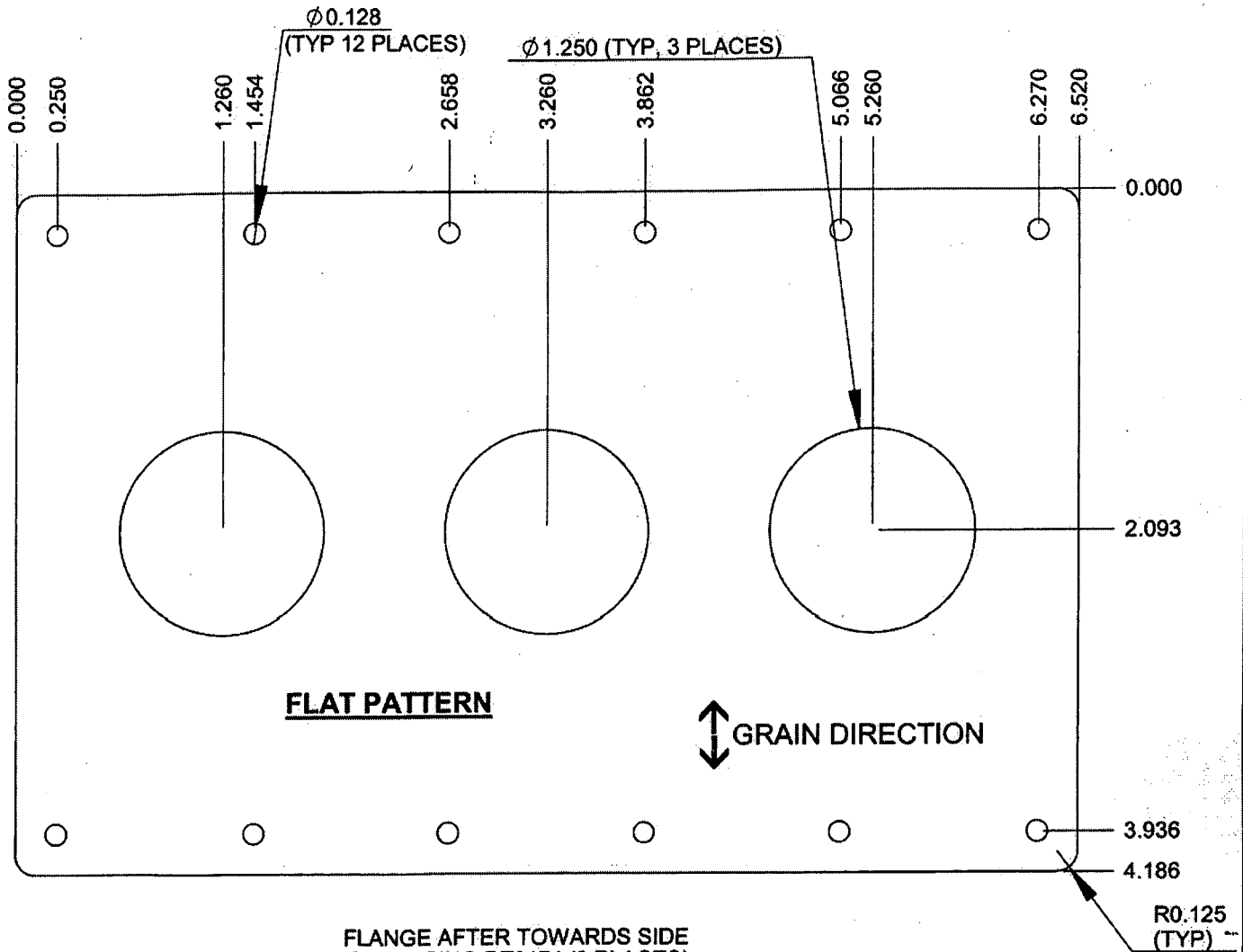
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02.09.20

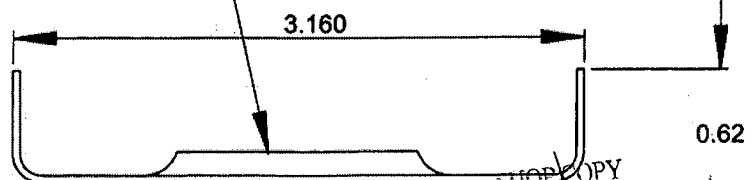
DART



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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3065	REV. A SHEET 3 OF 5
DATE 02.09.11	TITLE STEP LEG ASSEMBLY		SCALE 1:1



FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL

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WITHOUT NOTICE
WORK ORDER
NO. **26928B**

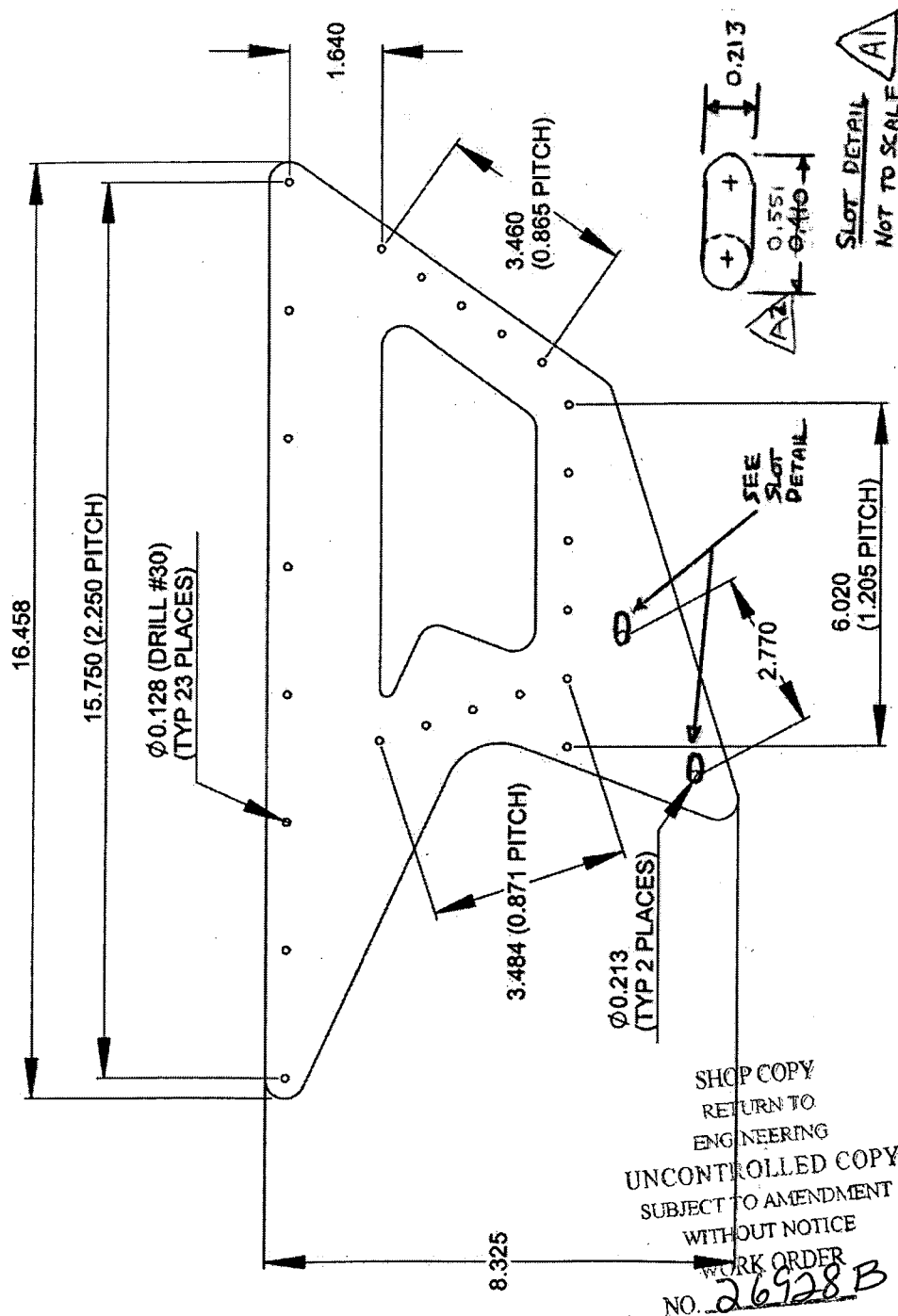
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 4 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY SCALE 1:3	

RELEASED
02.09.20 #



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPR1"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

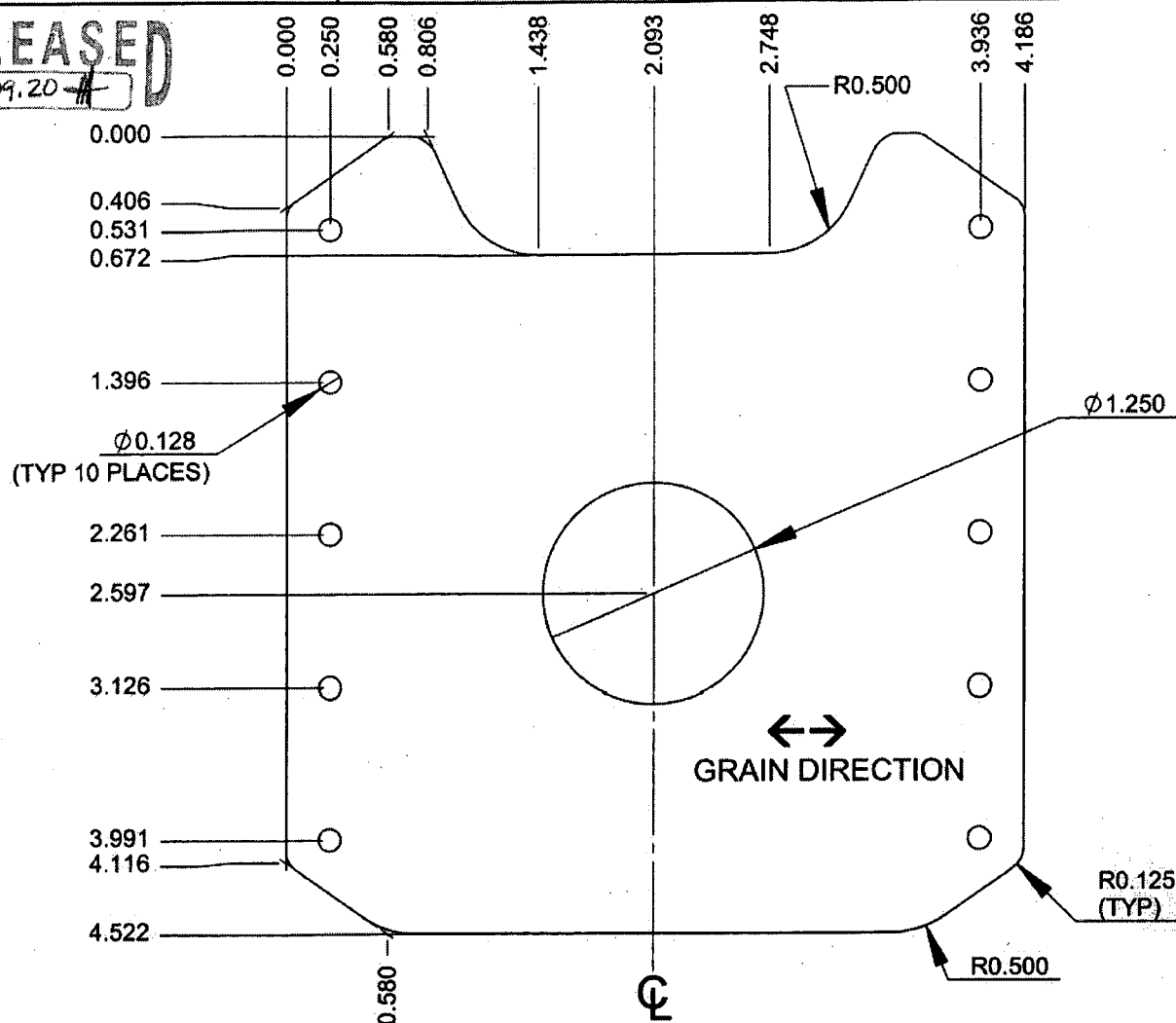
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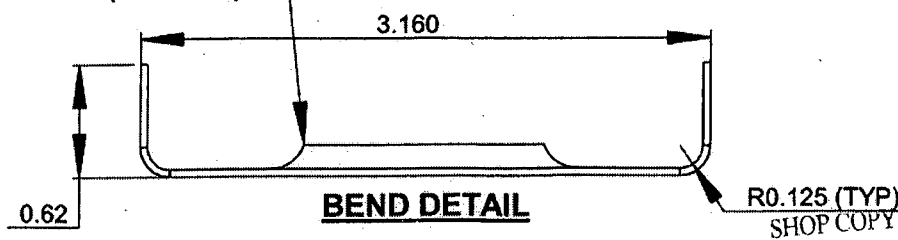
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. A SHEET 5 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20



FLAT PATTERN

FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)



BEND DETAIL

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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